

Work Order ID 160914

Friday, May 05, 2017 9:44:47 AM

160914

Page 1

Item ID: PB67-43001-15

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Adjustable Blade Support Assembly

Stop ***NS2***Start Date: 5/11/2017 Start Qty: ~~7.00~~ **2** ***7***

Cust Item ID:

Required Date: 5/25/2017 Req'd Qty: ~~7.00~~ ***7***

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 05 2017** Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-15	D

100 Weld per dwg A/R Aluminum rod Batch: **136158** 0.00***100***

Large Fab

Large Fab

Memo

8.47

2 JUN 06 2017**DAS 24 9-89**

1- Make a 0.090" chamfer in the 1.00" hole before welding

2- Grind weld flush in area of PB67-43001-249 only

3- Assemble and weld as per dwg

102

0.00

102

Mill Conv

Memo

2.50

Conventional Milling Machine

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT

INSTALL HELICAL INSERT

2 17-02-12
DAS 32 9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
STDS & C MUI									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

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Start Date: 5/11/2017 Start Qty: 7.00 ***7***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
105						②	17.06.12		DAS
QC	Memo	0.14							9
Quality Control									9-89
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110						②	17.06.12		DAS
QC	Memo	0.14							9
Quality Control									9-89
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160						2	φ 17.06.14		2348
Powdercoat	Memo	1.89							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								

START TIME: 1:55

OVEN TEMPERATURE: 370

FINISH TIME: 2:25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 4

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Revision ID: Stop ***NS2***
Item Name: Fwd Adjustable Blade Support Assembly
Start Date: 5/11/2017 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 5/25/2017 Req'd Qty: 7.00 ***7*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>W3</u>	0.00							
200									
Packaging	Memo	0.07							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.70							
Quality Control									

17/6/21 *[Signature]*

[Signature] JUN 20 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 160914

160914

Parent Item: PB67-43001-15

PB67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/11/2017

Required Date: 5/25/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS124780		Purchased	No			180	Each	12.0000	1	7			DAS
----------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	-----

MS124780

HELICAL INSERT

**

17-06-12

32
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST316	12	
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111064	12	m128173
--------	----	---------

MS27039-1-10

Purchased

No

180

Each

287.0000

8

56

**

JUN 19 2017

DAS
19
9-89

MS27039-1-10

SCREW

Location	Loc Qty	Loc Code
----------	---------	----------

GA	15	
----	----	--

m129541	15	
---------	----	--

ST280	272	
-------	-----	--

m137164	272	
---------	-----	--

NAS1149D0316J

Purchased

No

180

Each

1,053.000

8

56

**

JUN 19 2017

DAS
19
9-89

NAS1149D0316.J

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST264	1053	
-------	------	--

M134502	1053	
---------	------	--

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

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Parent Item: PB67-43001-15

PB67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/11/2017

Required Date: 5/25/2017

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0363J

Purchased

No

180

Each

629.0000

M 8 26
** 6 42

DAS
19
9-89

NAS1149D0363.J

Washer

JUN 19 2017

Location	Loc Qty	Loc Code
GA	42	
m134055	42	
ST263	587	
m137061	100	
m137164	487	

12

PB67-43001-249

Manufactured

No

100

Each

4.0000

1

**

7
JUN 06 2017

DAS
24
9-89

PB67-43001-249

Inner Tube Bushing

Location	Loc Qty	Loc Code
WA003	4	
133726	4	

2

PB67-43001-253

Manufactured

No

100

Each

0.0000

1

**

3160822 → 2 JUN 06 2017

DAS
24
9-89

PB67-43001-253

Gusset

PB67-43001-254

Manufactured

No

100

Each

0.0000

1

**

3160819 → 2 JUN 06 2017

DAS
24
9-89

PB67-43001-254

Gusset

PB67-43001-257

Manufactured

No

100

Each

1.0000

1

**

7
JUN 06 2017

DAS
24
9-89

PB67-43001-257

Inner Tube

Location	Loc Qty	Loc Code
Mezz2	1	
99970	1	

3160817 → 1

Friday, May 05, 2017 9:44:47 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
THIS IS A WORK ORDER				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, May 05, 2017 9:44:47 AM

Page 3

Work Order ID: 160914

160914

Parent Item: PB67-43001-15

PR67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/11/2017

Required Date: 5/25/2017

Start Qty: 7.00

Required Qty: 7.00

PB67-43001-71

Manufactured No

180

Each

1.0000

1

7

DAS
24
9-89

✓ ***PR67-43001-71***

20° Blade Support Assembly

**

JUN 06 2017

Location

Loc Qty

Loc Code

Mezz2

1

152104

1

180

Each

12.0000

1

7

DAS
19
9-89

PB67-43001-73

Manufactured No

PR67-43001-73

20 Degree Cover Plate

**

JUN 15 2017

Location

Loc Qty

Loc Code

Mezz2

2

138692

2

WA003

10

156064

10

180

Each

6.0000

1

7

DAS
19
9-89

PB67-43001-83

Manufactured No

PR67-43001-83

D-Pad Assembly, Short

**

JUN 19 2017

Location

Loc Qty

Loc Code

Mezz2

6

138687

6

160825

2

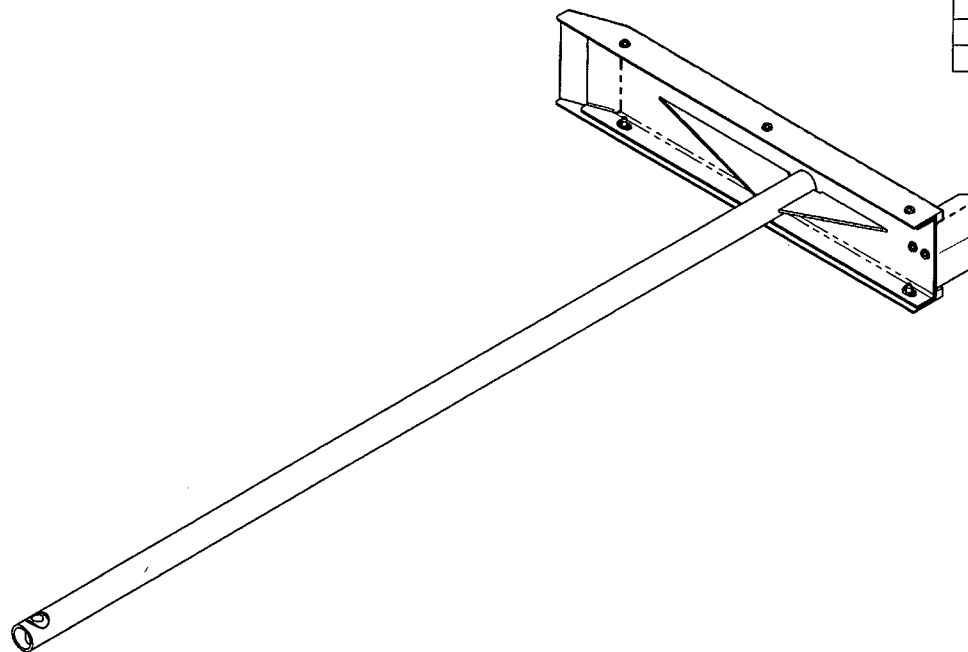
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval: _____		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER: ☐					



B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

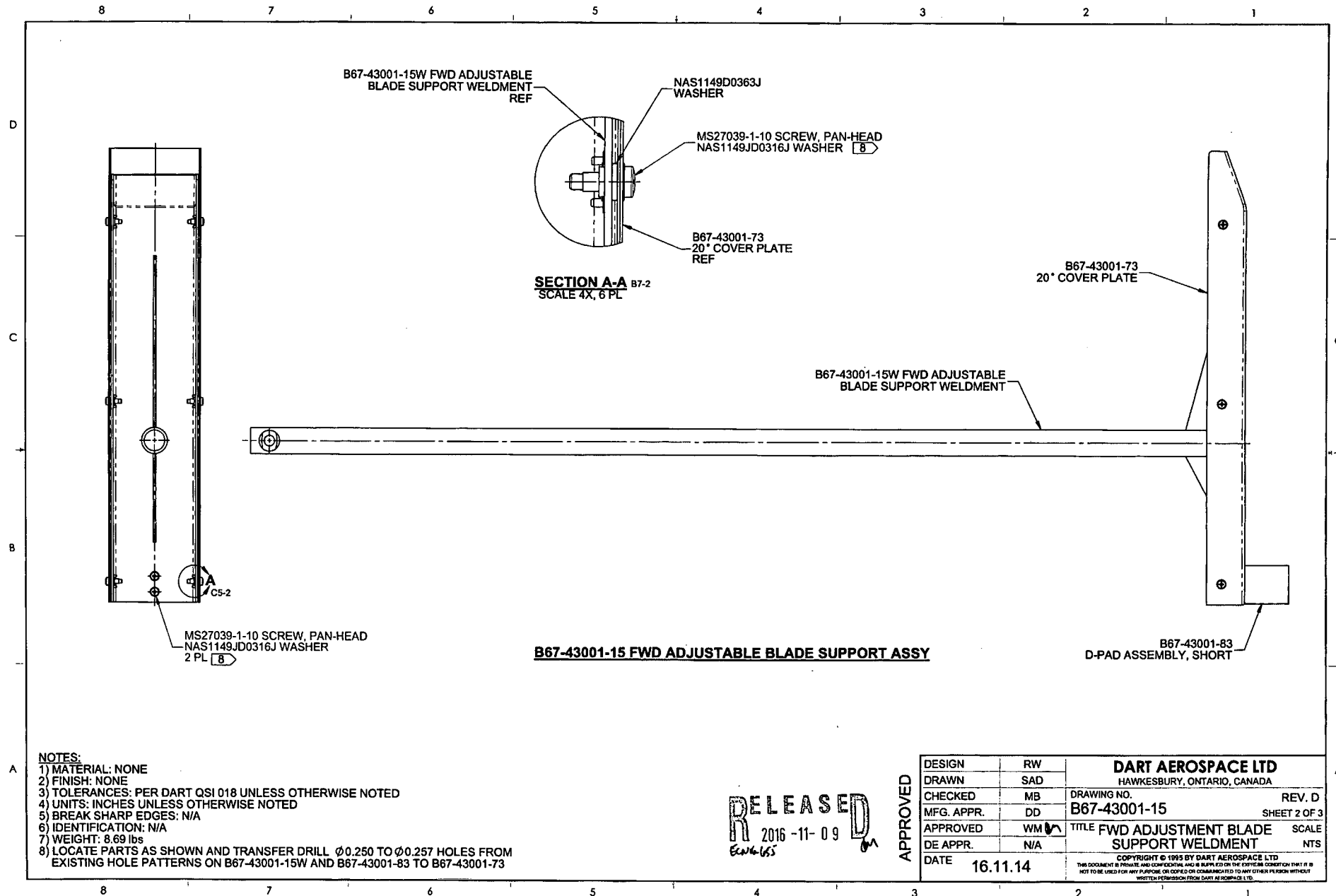
RELEASED
2016-11-09
ELW16655

ITEM	QTY -15	P/N	DESCRIPTION
1	X	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW, PAN-HEAD
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

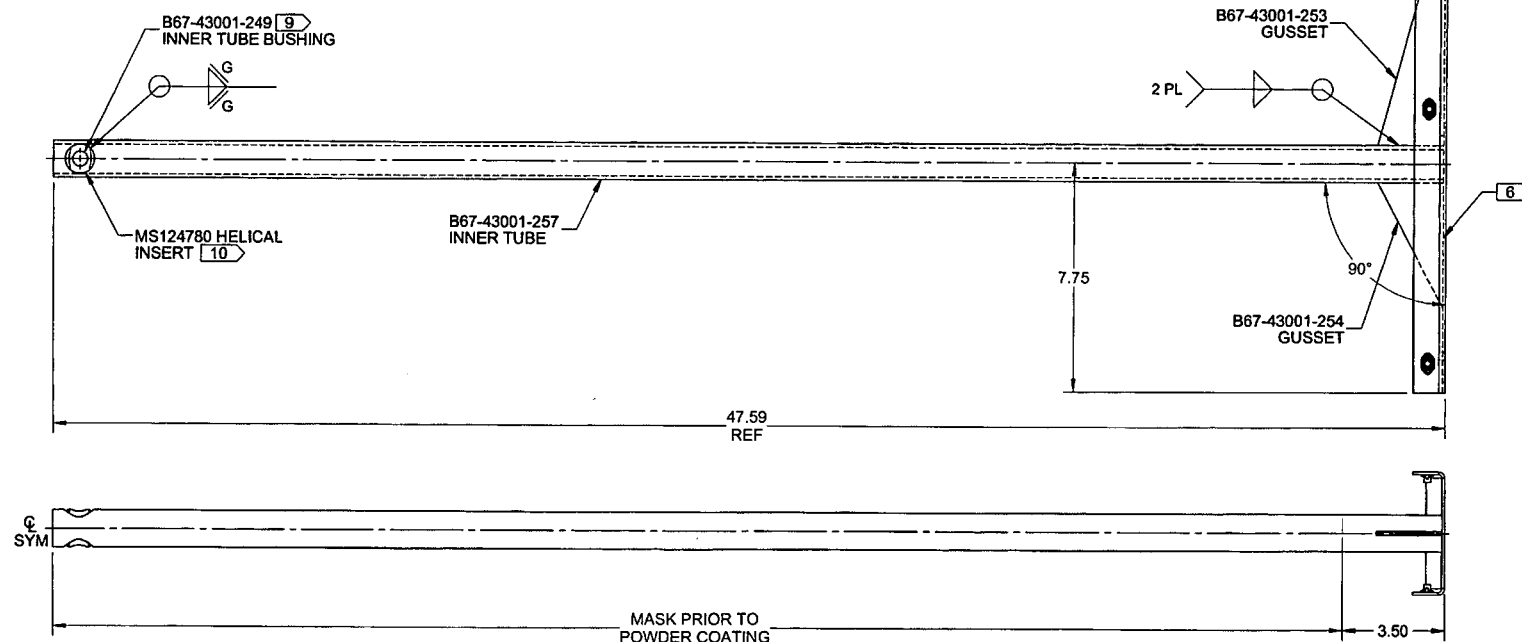
SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *160914 M.C.S*
170505

D	MERGE B67-43001-15W WITH B67-43001-15, REASON PAR15-437	SAD	16.11.14
C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043, FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-15	SHEET 1 OF 3
APPROVED	WM <i>WM</i>	TITLE	FWD ADJUSTMENT BLADE SCALE
DE APPR.	N/A	SUPPORT WELDMENT	NTS
DATE	16.11.14	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-15W	FWD ADJUSTABLE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-257	INNER TUBE
7	1	MS124780	HELICAL INSERT



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.35 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-15	SHEET 3 OF 3
APPROVED	WM	TITLE	FWD ADJUSTMENT BLADE
DE APPR.	N/A	SUPPORT WELDMENT	SCALE
DATE	16.11.14		NTS

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